



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4272-013
Job Sheet 177937



Part No: D4272-013

Job Qty: 1 ea

Part Name: Basket Assembly, Light Weight Lid, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/23/18

Job Tracking No:

Due Date: 6/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4272 REV D IPP Rev:A 10.11.19 new issue DD verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/20/18	6/20/18	0.00	0.00	Start Up Container		HL 18-6-13
100	Packaging	1 pcs	6/20/18	6/20/18	0.00	0.00	Packaging1-6		HL 18-6-14
110	HandFinish	1 pcs	6/20/18	6/20/18	0.00	0.00	HandFinish4		HL 18-6-14
120	QC	1 pcs	6/20/18	6/20/18	0.00	0.00	QC5		HL 18-6-14
130	Packaging	1 pcs	6/20/18	6/20/18	0.00	0.00	Packaging3		HL 18-6-14
140	QC21-FG	1 Ea	6/20/18	6/20/18	0.00	0.00	QC21		HL 18-6-14

Part Op 110 - TRANSFER DRILL FROM PLACARD INTO BASKET AS PER DWG ON SHEET 2 RIVET PLACARD AS PER DWG
Descriptions: ON SHEET 2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97447A010	Blind Rivet	4 pcs (4 ea)	90-Start up Operation	5019014
AN3-10A	Bolt	3 Ea (3 ea)	100-Packaging	5062291
AN3-14A	Bolt	4 Ea (4 ea)	100-Packaging	5062270
AN3-20A	Bolt	2 Ea (2 ea)	100-Packaging	FMI138084-70
AN310-4	Nut	3 Ea (3 ea)	100-Packaging	5060057
AN310C4	Nut	3 Ea (3 ea)	100-Packaging	5057194
AN4-12	Bolt	3 Ea (3 ea)	100-Packaging	5064082
AN4-13A	Bolt	6 Ea (6 ea)	100-Packaging	5053946
AN4C15	Bolt	1 Ea (1 ea)	100-Packaging	5068080
AN5-17A	Bolt	2 Ea (2 ea)	100-Packaging	5057451
AN5-21A	Bolt	2 Ea (2 ea)	100-Packaging	5059872
D2530	Handle Weldment	1 Ea (1 ea)	100-Packaging	5054449
D2535	Spring	2 Ea (2 ea)	100-Packaging	5050469
D2537	Bushing	2 Ea (2 ea)	100-Packaging	5077936
D2690-6	Lanyard	2 Ea (2 ea)	100-Packaging	F 861B
D2931	Bumper	2 Ea (2 ea)	100-Packaging	5069248
D3912-041	Eyebolt Receiver Assembly	1 Ea (1 ea)	100-Packaging	5074254
D3915-041	Light Lid Assembly, Long Basket	1 Ea (1 ea)	100-Packaging	5057741 (x5)
D3917-3	Washer	6 Ea (6 ea)	100-Packaging	5067458
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	100-Packaging	5051316
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	100-Packaging	5051311
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	100-Packaging	

DART
AEROSPACE

1670 ROUTE 100
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S080467



Part: D4272-013

Job No: 177937

Serial No/Batch: S080467

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 06/12/18

441
32
33-0
340
12
35-0

D3953-3	Gas Spring Stud, Lid	5064794	2 Ea (2 ea)	100-Packaging	5075339
D3953-7	Spring Spacer		2 Ea (2 ea)	100-Packaging	5059063
D3953-9	Gas Spring Washer		2 Ea (2 ea)	100-Packaging	5075339
D3969-3	Spring (Basket Lid)		1 Ea (1 ea)	100-Packaging	5064097
D4021-5	Blanking Plate		1 Ea (1 ea)	100-Packaging	5067452
D4150-041	Attachment Arm Assembly		1 Ea (1 ea)	100-Packaging	5075977
D4151-041	Basket Fwd Hardpoint Assembly, Lower		1 Ea (1 ea)	100-Packaging	5072903
D4151-043	Basket Fwd Hardpoint Assembly, Upper		1 Ea (1 ea)	100-Packaging	5063717
D4273-041	Basket Base Assembly, LH	5677942	1 Ea (1 ea)	100-Packaging	F131261
D4307-265	Placard, Max Load		1 Ea (1 ea)	100-Packaging	F131261
MS17984-C413	Quick Release Pin		2 pcs (2 ea)	100-Packaging	5068650
MS20600-AD4W3	Cherry Rivet		2 Ea (2 ea)	100-Packaging	5042091
MS21042L3	Nut		9 Ea (9 ea)	100-Packaging	5075322
MS21042L4	Nut		6 Ea (6 ea)	100-Packaging	5078251
MS21042L5	Nut		4 Ea (4 ea)	100-Packaging	5041167
MS24665-151	Cotter Pin		4 Ea (4 ea)	100-Packaging	5053951
MS24665-300	Cotter Pin		2 Ea (2 ea)	100-Packaging	5044182
NAS1149C0432R	Washer		2 Ea (2 ea)	100-Packaging	5050052
NAS1149C0463R	Washer		3 Ea (3 ea)	100-Packaging	5053953
NAS1149DN832J	Washer		2 Ea (2 ea)	100-Packaging	5034411
NAS1149F0332P	Washer		14 Ea (14 ea)	100-Packaging	5068662
NAS1149F0432P	Washer		18 Ea (18 ea)	100-Packaging	5050055
NAS1149F0563P	Washer		4 Ea (4 ea)	100-Packaging	5054111
NAS1515H4L	Washer		2 Ea (2 ea)	100-Packaging	5044184

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97447A010	4	738	0
100-Packaging	AN3-10A	3	131	0
	AN3-14A	4	242	0
	AN3-20A	2	13	0
	AN310-4	3	124	0
	AN310C4	3	136	0
	AN4-12	3	64	0
	AN4-13A	6	1,580	0
	AN4C15	1	55	0
	AN5-17A	2	234	0
	AN5-21A	2	103	0
	D2530	1	16	0
	D2535	2	29	0
	D2537	2	36	0
	D2690-6	2	10	0
	D2931	2	1,038	0
	D3912-041	1	13	0
	D3915-041	1	2	0
	D3917-3	6	43	0
	D3953-17	2	87	0
	D3953-19	1	48	0
	D3953-21	1	42	0
	D3953-3	2	24	0
	D3953-7	2	36	0
	D3953-9	2	17	0
	D3969-3	1	26	0
	D4021-5	1	56	0
	D4150-041	1	7	0
	D4151-041	1	11	0
	D4151-043	1	10	0
	D4273-041	1	0	0
	D4307-265	1	7	0
	MS17984-C413	2	37	0
	MS20600-AD4W3	2	203	0
	MS21042L3	9	1,599	0
	MS21042L4	6	2,836	0
	MS21042L5	4	741	0
	MS24665-151	4	384	0
	MS24665-300	2	88	0
	NAS1149C0432R	2	2,289	0
	NAS1149C0463R	3	260	0

NAS1149DN832J	2	1,864	0
NAS1149F0332P	14	3,675	0
NAS1149F0432P	18	1,555	0
NAS1149F0563P	4	725	0
NAS1515H4L	2	331	0

Part Specifications

Specifications could not be found.

Plex 5/23/18 11:37 AM Dart.lajeunesse.marie

Linda Lacelle

From: Chris Provencal
Sent: Thursday, June 7, 2018 3:55 PM
To: Linda Lacelle; Lacey Cantin
Cc: Jean-Luc Menard; David Shepherd; Harvey Siemens; Steven Drouin
Subject: RE: order 4897

Linda,

Until engineering addresses the manufacturability, we will have no choice but to manufacture D4029 to Rev. A and release on deviation.

Chris

From: Linda Lacelle
Sent: Thursday, June 07, 2018 2:40 PM
To: Lacey Cantin <lacantin@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>
Subject: RE: order 4897
Importance: High

Chris, we really require a response on this please!!!!

From: Linda Lacelle
Sent: Wednesday, June 6, 2018 12:31 PM
To: Lacey Cantin <lacantin@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: RE: order 4897

So?? Chris??

From: Lacey Cantin
Sent: Wednesday, June 6, 2018 10:25 AM
To: Linda Lacelle <llacelle@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>

Under Review Notification

Raised By: Steven Drouin

Date: 18.06.01

Product #: D407-797/D350-607/D206-797

Product Name: 407,206,350 Basket

Part Number (D-Part and 9-Digit) (eg. D3535-11) (eg. D3535-25) (eg. D206-642-143) (eg. RBEM324U3010101-1)	Drawing or Document & <u>Current</u> Affected Revision for each part listed	"Y" or "N" Required for Each Part Do not leave blank							Reserved ECN Log Number	Instructions Relevant to Each Part (including whether CHG #'s will be affected)
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	PP Under Review	Product Specifications Under Review ("Bluefiles")		
D4029-041/-043	D4029 Rev. B	Y	Y	Y	Y	Y	Y	N	737	Design change
D407-797-101	IIN-D407-797 Rev. C	Y	Y	Y	Y	Y	Y	Y	737	Change # 001 002
D407-797-013	IIN-D407-797 Rev. C	Y	Y	Y	Y	Y	Y	Y	737	Change # 006
D407-797-014	IIN-D407-797 Rev. C	Y	Y	Y	Y	Y	Y	Y	737	Change # 006
D206-797-023	IIN-D407-797 Rev. C	Y	Y	Y	Y	Y	Y	Y	737	Change # 006
D206-797-024	IIN-D407-797 Rev. C	Y	Y	Y	Y	Y	Y	Y	737	Change # 006
D350-607-543	IIN-D350-607 Rev. J	Y	Y	Y	Y	Y	Y	Y	737	Change # 009
D350-607-547	IIN-D350-607 Rev. J	Y	Y	Y	Y	Y	Y	Y	737	Change # 009
D350-607-505	IIN-D350-607-3 Rev. E	Y	Y	Y	Y	Y	Y	Y	737	Change # 001
D350-607-503	IIN-D350-607-3 Rev. E	Y	Y	Y	Y	Y	Y	Y	737	Change # 001
D3915-041	D3915 Rev. F	Y	Y	Y	Y	Y	Y	N	737	Revise
D4019-041	D4019 Rev. G	Y	Y	Y	Y	Y	Y	N	737	Revise
Description of Issue: D4029 Webbing material (stack up) making basket lid unable to close on the basket base Basket cannot be sent to customer because of this issue Please advise Engineering if creating a work order Only customers Supplied with D4029-041/043 Rev B webbing must be notified										

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

H:\Forms\Engineering\approved online eng\URF revD.xls

D407 797-013
✓
order 4097
June 26

D4272-013
D3915-041

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
5725 2 87x0h x 821 591 069 591 029								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																